

Date: Tuesday, 11/14/2006 10:07:49 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE FITTING
Job Number :	29432		
Estimate Number :	12299		
P.O. Number :	N/A	Part Number :	D3488041
This Issue :	11/14/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3488 / DSK101
First Issue :	N/A	Project Number :	N/A
Previous Run :	28318	Drawing Revision :	B / D
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	12/15/2006
Written By :			Qty: 16
Checked & Approved By :			Um: 20
Comment :	Each		
	Est Rev:A New Issue 06-02-28 JLM		
	Est Rev:B As per Rev B 06-03-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6103003	alum billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Alluminum Round Billet D6103-003 Batch: 3070		
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE 1-Turn as per Dwg DSK 101 & Folio FA625 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA625 & Dwg D3488 2-Deburr		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:07:49 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 29432

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F 07/02/19 16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YH/M.H 07/02/26 X 16

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

F.L/M.H 07/02/26 (B)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

YH 07/02/28 X 16

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert 19393

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

MS

07-03-28

(15)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/23 (15)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

YH 07-03-28 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:07:49 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 29432

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE



07/03/26

Job Completion



U. 07-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29432
Description: Blade Fitting, LH		Part Number:	D3488-1
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

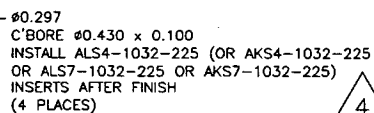
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.129	✓			
2.620	+/-0.010	2.620	✓			
0.793	+/-0.010	.795	✓			
1.351	+/-0.010	1.343	✓			
1.317	+/-0.010	1.316	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.801	✓			
Ø0.508	+0.006/-0.001	.511	✓			
R0.062	+/-0.010	5.062	✓			
1.500	+/-0.010	1.500	✓			
8.000	+0.030/-0.000	8.001	✓			
11.18	+/-0.030	11.172	✓			
Ø0.484	+0.005/-0.001	.487	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.149	✓			
3.070	+/-0.010	3.075	✓			
0.590	+/-0.010	.597	✓			
0.125	+/-0.010	.125	✓			
1.005	+/-0.010	1.006	✓			
3.500	+/-0.010	3.499	✓			
Ø0.297	+0.005/-0.000	.300	✓			
Ø0.430	+/-0.010	.432	✓			
0.100	+/-0.010	.098	✓			

Measured by: BG / J.L	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/02/18	Date: 07/02/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	[Signature]



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)

2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

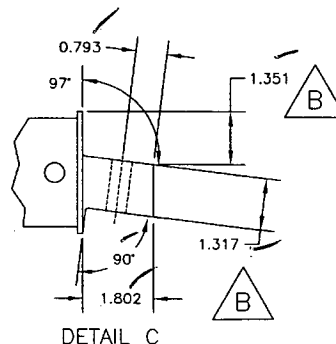
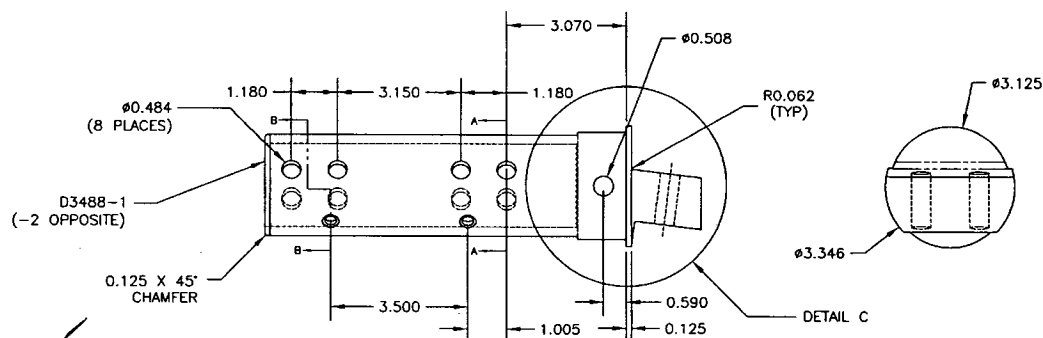
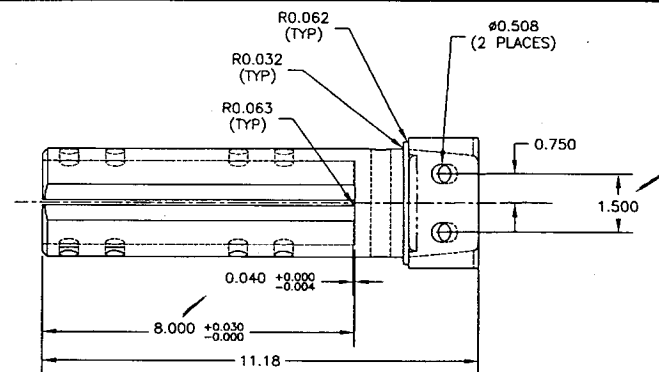
4) INSTALL INSERTS AFTER POWDER COAT

5) ALL DIMENSIONS ARE IN INCHES

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


WORK ORDER

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
N^o 3
29432



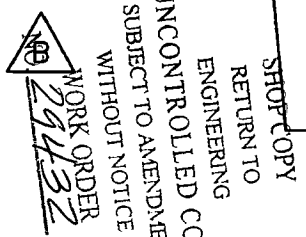
D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
04.03.49 AM
PER OS
ELN 4789

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. PORT HADLOCK, MA
PH	PH	
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3488
DATE	TITLE	
06.03.15	BLADE FITTING	

DART

U.S. 04



- DSK 101

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